

DG101-002

Work Order ID 164326

Tuesday, July 18, 2017 9:53:19 AM

164326

Page 1

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Aft, Out

Start Date: 7/18/2017 Start Qty: 6.00

6
6

Cust Item ID:

Required Date: 7/21/2017 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2573	F

100

2.21

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

4.42

HAAS CNC vertical machine #1

Program Batch No. 164326

Double check by: 

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

4 0 DAS 44 9-09 17-08-17

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.54

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

4 0 DAS 44 9-09 17-08-17

Work Order ID 164326

Tuesday, July 18, 2017 9:53:19 AM

164326

Page 2

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.06				4	0		DAS 44 9-89 17-08-17
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				4	0		DAS 14 9-89 17/08/19
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.52				(4)	0		2017-08-24 BL/JSL

Work Order ID 164326

Tuesday, July 18, 2017 9:53:19 AM

164326

Page 3

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m B8041.</i> Memo START TIME: <i>3:40.</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>4:10.</i>	0.00 0.12				<i>4</i>	<i>0</i>	<i>17-08-28.</i>	<i>DAS 34 9-89</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.06				<i>4</i>			<i>DAS 38 9-89</i> <i>4106 0-6 0114</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>51398</i> Memo	0.00 0.06				<i>4</i>		<i>AUG 2-9 2017</i>	<i>ne</i>

Work Order ID 164326

Tuesday, July 18, 2017 9:53:19 AM

164326

Page 4

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, Out
Start Date: 7/18/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 7/21/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.60							
Quality Control									

DAS
21
9-89

AUG 3 0 2017

Picklist Print

Tuesday, July 18, 2017 9:53:17 AM

Page 1

Work Order ID: 164326

164326

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 7/18/2017

Required Date: 7/21/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	24.0000	1	64			
D6101-007									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT041

24

159162

4

159705

20

164013

2 SBL 2017/08/11
2

DART AEROSPACE LTD	Work Order: 164326
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.501	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.504	.503	.504	.504		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.125	.125	.127	.125		
R	0.240	0.260		.252	.252	.253	.253		
S	0.115	0.135		.126	.126	.129	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.242	.242	.242	.242		
W	0.115	0.135		.124	.126	.123	.125		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.252	.251	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.249	.250	.251	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.032	.033	.033		
Accept/Reject								DAS	

Measured by: 44
Date: 17-08-17

Audited by: 14
Date: 17/08/19

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

